

Work Order ID 83826

Thursday, April 26, 2012 1:07:48 PM

83826

ASAP

Page 1

Item ID: D4125-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: End

Start Date: 4/26/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MFDate: 12-04-26

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4125

C

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1-Cut Blank at 6.500"

JL 12-04-28

⑥

105

0.00

105

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machined as per folio FB079

Rev: AADwg: 2

Deburr

an 12/04/29

12-4-30

6

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Hand Finishing

02/04/20
12-4-30

SL 12-04-30

⑥ NG 12-5-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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83826

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N900040100

Setup Start *NS1*

Stop *NS2*

6

Cust Item ID:

6

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------------	---------------	------------------	----------------

0.00

140

QC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location: WA 0.00

150

Packaging

Packaging

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 83826

Parent Item: D4125-3

Parent Item Name: End

Start Date: 4/26/2012

Required Date: 5/3/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.07.21 new issue DD verf:EC
JFS verf:DD

IPP Rev:B 11/12/05 as per rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X08.000 6061-T6 BAR 2.00' X 8.00"		Purchased	No			100	f	16.5094	0.542	3.4231579			

Location

Loc Qty

Loc Code

MAT005

16.5094

119805

16.5094

SL 12-04-28

3.43

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

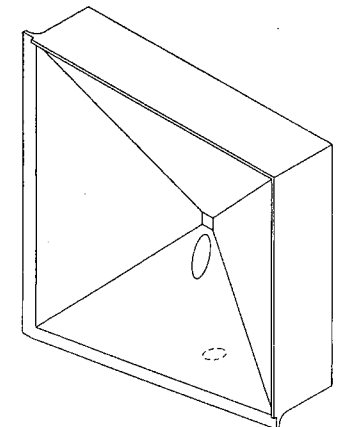
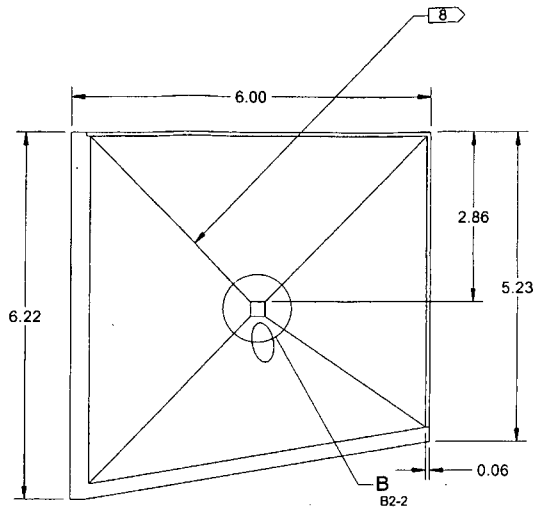
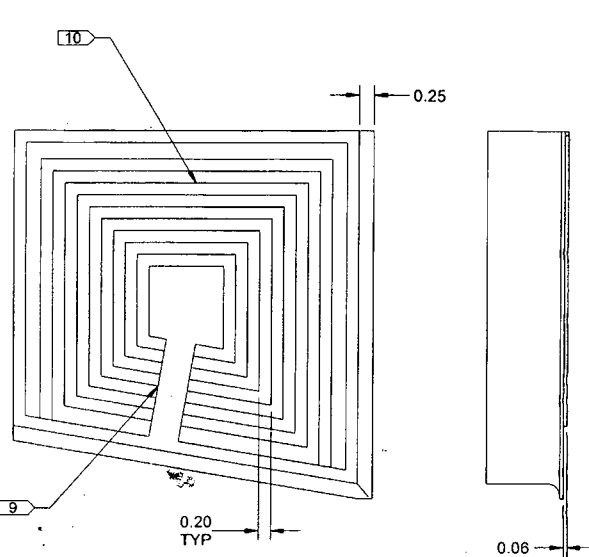
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

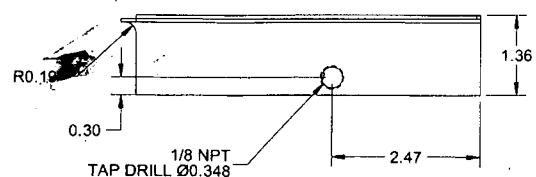
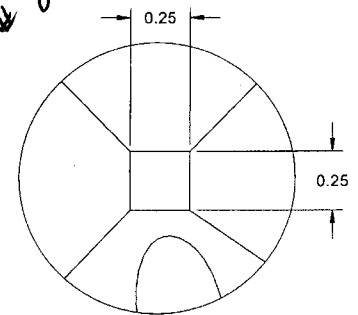
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8 7 6 5 4 3 2 1



83524









DETAIL B
SCALE 4X
C4-2

RELEASE
2012-03-02

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B1.750X6.000
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.16 lbs
 - 8) MAXIMUM INSIDE RADIUS = 0.250
 - 9) MINIMUM RADIUS = 0.187
 - 10) MINIMUM RADIUS = 0.015

3.330

△ D4125-3 AFT SEDIMENT BOWL

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4125	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SEDIMENT BOWLS	NTS
DATE	11.11.29	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

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